

Work Order ID 106481-2

September-03-13 2:29:34 PM

106481

Page 1

Item ID: D119-675-011

Revision ID:

Item Name: Heli-Access-Step LH

Start Date: 9/03/13

Start Qty: 3.00

Required Date: 9/03/13

Req'd Qty: 3.00

Reference: ECN13-627

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI9647

A

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D119-675-011 CHG005
ADD PAPERWORK DSI9647 TO EACH KIT

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

PULL FROM STOCK:
2 X D119-675-011 B84002
1 X D119-675-011 B76854 -CHG004

ADD TO EACH KIT PER ECN13-627

4 X D2732-0.32
4 X D3041-5
4 X D3041-7
8 X AN4-16A
8 X AN960JD416 (NAS1149D0463J)
8 X MS21042L4

DART Dart Aerospace Ltd. 3270 ABERDEEN ST. HAWKESBURY ON CANADA K6A 1K7				TO APPROVAL # 09-09 TEL: 1-613-632-5200	
P/N	D119-675-011	CHG	CHG004		
DESC.	Heli-Access-Step, LH	STC	SR00948SE		
LOT	B76854	STC			
MODEL	Agusta A119/AW119MKII	STC			
MADE IN CANADA					
02/29/97					

Work Order ID 106481***106481***

Page 2

September-03-13 2:29:34 PM

Item ID: D119-675-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 9/03/13 Start Qty: 3.00

3

Cust Item ID:

Required Date: 9/03/13 Req'd Qty: 3.00

3

Customer:

Reference: ECN13-627

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Quality Control

Memo



0.00

13-9-19

130

0.00

130

Packaging

Packaging

Packaging

Memo

REPACKAGE PER PPP USING NEW B/N
AT CHG005, NEW LABELS REQ'D
ADD PAPERWORK DSI9647 TO EACH KITIdentify and pack for shipping as per PPP D119-675-011
Location: _____

0.00

1 8 13-9-23

140

0.00

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

10 / 13-09-23

UMF
13-9-23

Picklist Print

Page 1

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Work Order ID: 106481
Parent Item: D119-675-011
Parent Item Name: Heli-Access-Step LH

Start Date: 9/03/13
Start Qty: 3.00

Required Date: 9/03/13
Required Qty: 3.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP RevE change at rev.b as per ECN1107 DD verified by: IPP REV:F 13.09.03 chg005 /
DSI9647 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN416A
BOLT

Purchased

No

Each 440.0000

8 8

Location	Loc Qty	Loc Code
FG	5	
121541	5	
ST357	8	
124215	8	
ST514	247	
125427	200	
M126073	47	
ST515	180	
125396	180	

D119-675-011
Heli-Access-Step LH

Manufactured

No

Each 0.0000

D2732
Rubber Extrusion
4 X D2732-032

Manufactured

No

f 206.8962

4 1.068

Location	Loc Qty	Loc Code
ST410	206.8962052	
70987	0.3	
83560	3.5962052	
94725	203	

Manufactured

No

Each 11.0000

D3041-S
Clamp

Location	Loc Qty	Loc Code
ST462	11	
37633	11	

376.33 7x

DA
32
88

Picklist Print

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Work Order ID: 106481
 Parent Item: D119-675-011
 Parent Item Name: Heli-Access-Step LH

Start Date: 9/03/13

Required Date: 9/03/13

Start Qty: 3.00

Required Qty: 3.00

D3041-7

Clamp

Manufactured No

Each 11.0000

2 6 #2 32 32
 50

Location

Loc Qty

Loc Code

ST462

11

37634

11

Each 5,221.0000

37634
 8 8 SP 13-9-3 32 32
 50

MS21042L4

Locknut

Purchased No

Location

Loc Qty

Loc Code

FP001

50

122452

38

8182

12

ST314

10

m125708

10

st507

56

125535

23

m126073

33

ST509

4000

m126275

4000

ST510a

915

m126333

915

ST518

190

124231

190

24x

Picklist Print

Page 3

September-03-13 2:29:34 PM

Work Order ID: 106481
Parent Item: D119-675-011
Parent Item Name: Heli-Access-Step LH

Start Date: 9/03/13

Required Date: 9/03/13

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0463J

Purchased

No

Each

5,552.0000

8

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	2	
122441	2	
ST007	24	
121912	24	
ST294	149	
119097	1	
124198	35	
124778	113	
ST510a	5377	
<u>M126221</u>	5377	

SP13-9-3

32

September-03-13 2:29:34 PM

Shop Packet Print

Page 3

List Lots

Page 1 of 1

September-03-13 12:58:44 PM

Criteria : Item ID: 'D119-675-011', 'D119-675-012' All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
Item Name	Location ID							
D119-675-011 Heli-Access-Step LH	Main Warehouse	76854	6/18/12	1.0000		QC21	CHG004	
	FG070							
	Main Warehouse	84002	11/26/12	2.0000		QC21	CHG004	
	FG070							
			Total:	3.0000				
D119-675-012 Heli-Access-Step RH	Main Warehouse	84003	11/12/12	3.0000		QC21	CHG004	
	FG070							
	Main Warehouse	86161	9/13/12	2.0000		QC21	CHG004	
	FG070							
			Total:	5.0000				

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-675 REV. B AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-675 REV. 2
REF. FAA STC SR00948SE & EASA STC EASA.IM.R.S.01458

1.0 INTRODUCTION:




The purpose of this Service Instruction is to improve installation of D119-675-011/-012 *Heli-Access-Steps*. This improvement consists of replacing the inboard D3042-1 Clamps and D2182B032 Rubber Cushions with D3041-5/-7 Clamps and D2732-032 Rubber Cushions.

For existing installations (D119-675-011/-012 *Heli-Access-Steps* @ Change 004 or earlier), this service instruction also recommends removal of the D2617-5 Bushings at the aft crosstube position to prevent the bearings in the D3041-1/-3 clamps from being pushed out and makes it permissible for operators to raise the step an additional 2.00 inches (51mm) to provide clearance for the ground handling wheels. Refer to section 2.0 of this Service Instruction.

New installations steps (D119-675-011/-012 *Heli-Access-Steps* @ change 005 or later) will have their parts list and instructions amended accordingly. Refer to section 3.0 of this Service Instruction.

2.0 INSTALLATION OF DSI 9647-011 CLAMP REPLACEMENT KIT:

- 2.1 The DSI 9647-011 Clamp Replacement Kit can be procured from Dart. One kit upgrades one step.
- 2.2 Remove and discard the D3042-1 Clamps, D2182B032 Rubber Cushions and hardware. Replace with the D3041-5/-7 Clamps, D2732-032 Rubber Cushions and hardware as shown in Section B-B and C-C of this Service Instruction.
- 2.3 Tighten clamp bolts. Do not exceed torque of 60 in-lb (6.8 nm) on the nuts.
CAUTION: Over-torquing the nuts could lead to structural damage of the clamps.
- 2.4 Amend weight and balance per section 4.0 of this Service Instruction.

A	NEW ISSUE	AJS	13.04.04
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9647	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CLAMP REPLACEMENT	NTS
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3.0 INSTALLATION INSTRUCTIONS:

For D119-675-011/-012 *Heli-Access-Steps* @ CHG 005 or later.

Step installations for the A119/AW119 MKII rotorcraft are illustrated in Figure 1 and View A-A, Sections B-B, and C-C of this Service Instruction.

3.1 Remove the existing crosstube-mounted short steps.

- a) For **A119 model** aircraft, remove the Agusta P/N 109-0570-33-101/-103 step by drilling out the 4 attachment rivets per step. Plug holes with rivets and touch up paint per the Aircraft Maintenance Manual as required.
- b) For **AW119 MKII model** aircraft, remove the Agusta P/N M031-01S002-041 step by removing the MS21920-20/-22 clamps. Touch up paint per the Aircraft Maintenance Manual as required.

NOTE: It is acceptable to leave the short steps on the landing gear provided they do not interfere with the installation of the Dart step in accordance with the dimensions shown in View A-A of Figure 1.

3.2 Install the D3041-1/-3 Clamps on the step as follows.

- a) For **A119 model** aircraft, install the D3041-1/-3 Clamps per Sections B-B and C-C of this Service Instruction.
- b) For **AW119 MKII model** aircraft, install the D3041-1 Clamps per Sections B-B and C-C of this Service Instruction.

3.3 Present the step to the outboard side of the crosstubes. Propping the step at the appropriate height (see Figure 1) can facilitate installation.

3.4 Install the D2732-032 Rubber Cushions under the D3041-1/-3/-5/-7 Clamps (see Sections B-B and C-C (of this DSI)).

3.5 Find the appropriate step height by locating the step/clamp as shown in View A-A. Locate the forward D3041-1/-3 Clamp 7.8"- 10.4" above the crosstube cuff. Locate the aft D3041-1 Clamp 7.8"-11.6" above the crosstube cuff. The distances given are from the crosstube cuff to the bottom-most clamp.

3.6 Tighten the clamp bolts. Do not exceed torque of 60 in-lb (6.8 Nm) on the nuts.

CAUTION: Over-torquing the nuts could lead to structural damage of the clamps.

3.7 Amend weight and balance per section 4.0 of this Service Instruction.

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MFG. APPR.	N/A	DSI 9647	SHEET 2 OF 6
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4.0 WEIGHT AND BALANCE:

Use the following Weight and Balance for D119-675-011/-012 @ CHG 005 or later.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011	11.8 lb	-32.4 in	-382 in-lb	121.3 in	1431 in-lb
Heli-Access-Step™, LH	5.4 kg	-1.28 m	-6.9 m-kg	3.08 m	16.6 m-kg
D119-675-012	11.8 lb	+32.4 in	+382 in-lb	121.3 in	1431 in-lb
Heli-Access-Step™, RH	5.4 kg	+1.28 m	+6.9 m-kg	3.08 m	16.6 m-kg

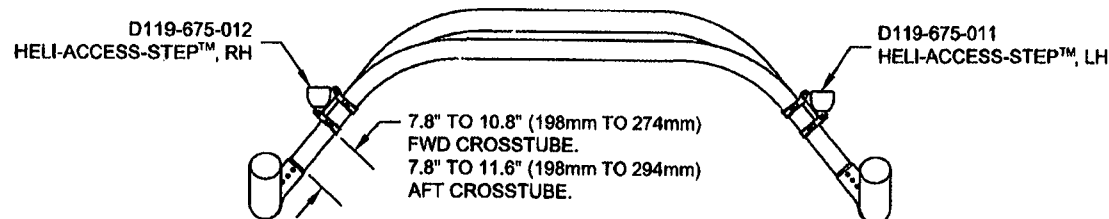
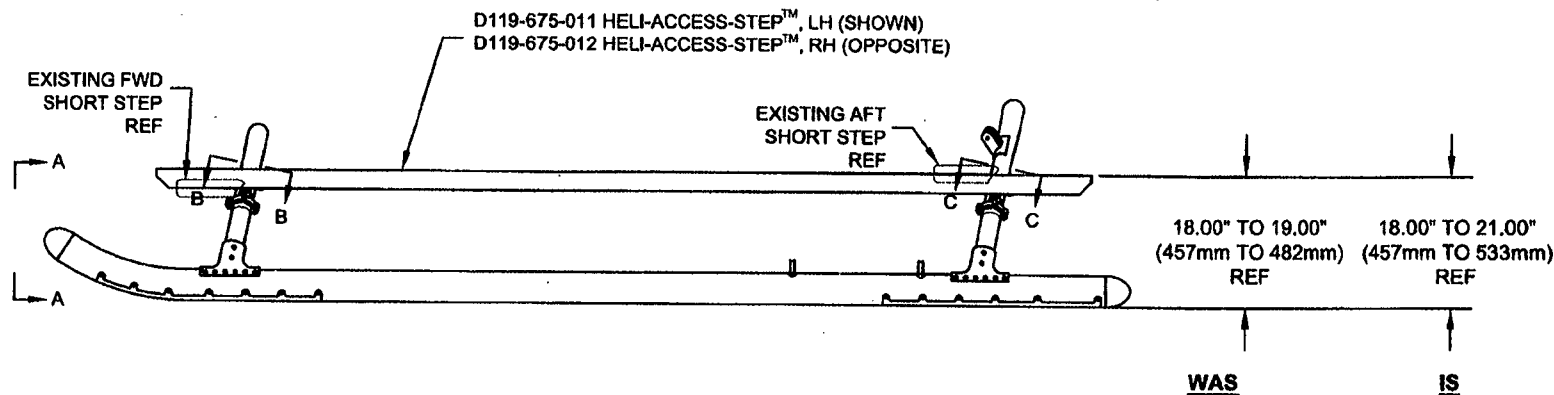
5.0 PARTS LISTS:

QTY -011	Part Number	Description
X	DSI 9647-011	CLAMP REPLACEMENT KIT
4	D2732-032	RUBBER CUSHION
4	D3041-5	CLAMP
2	D3041-7	CLAMP
8	AN4-16A	BOLT
8	AN960JD416	WASHER
8	MS21042L4	BOLT

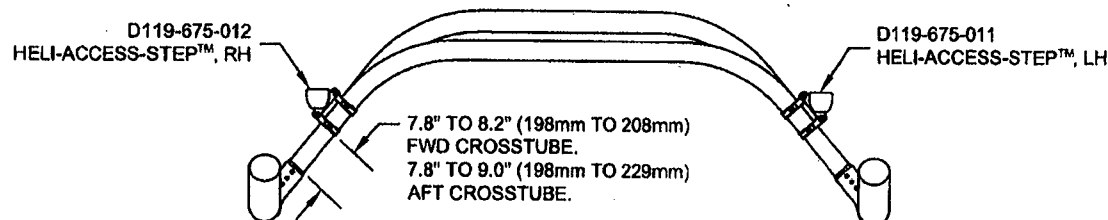
Use the following Parts List for D119-675-011/-012 @ CHG 005 or later.

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	HELL-ACCESS-STEP™, LH
	X	D119-675-012	HELL-ACCESS-STEP™, RH
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
4	4	D2617-5	BUSHING
8	8	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3041-5	CLAMP
2	2	D3041-7	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
8	8	AN4-16A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9647	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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VIEW A-A

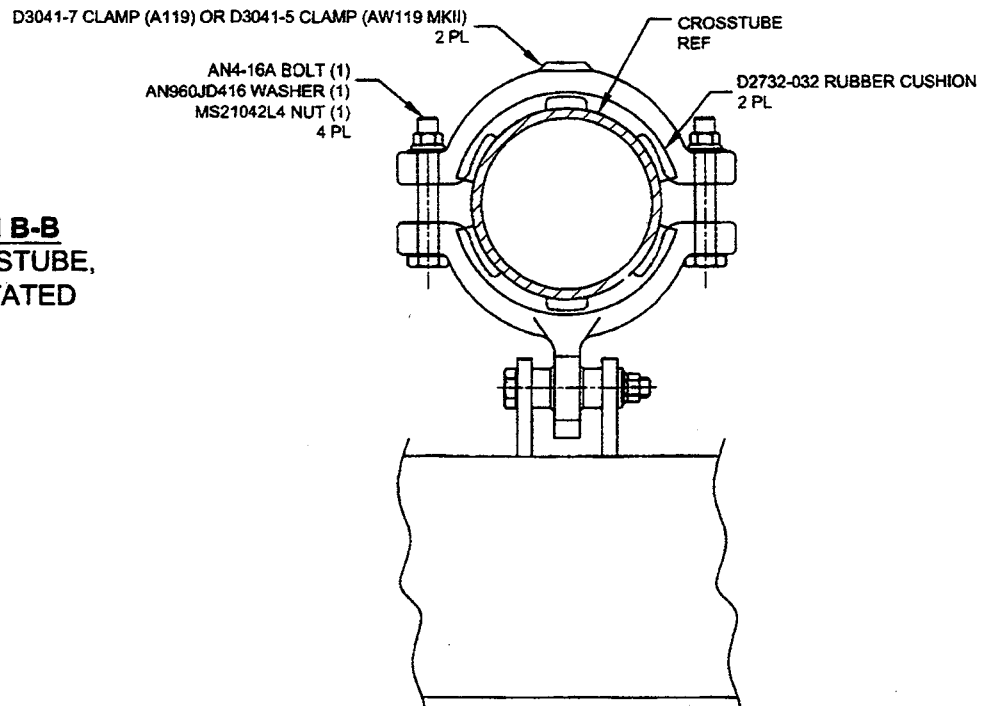


VIEW A-A

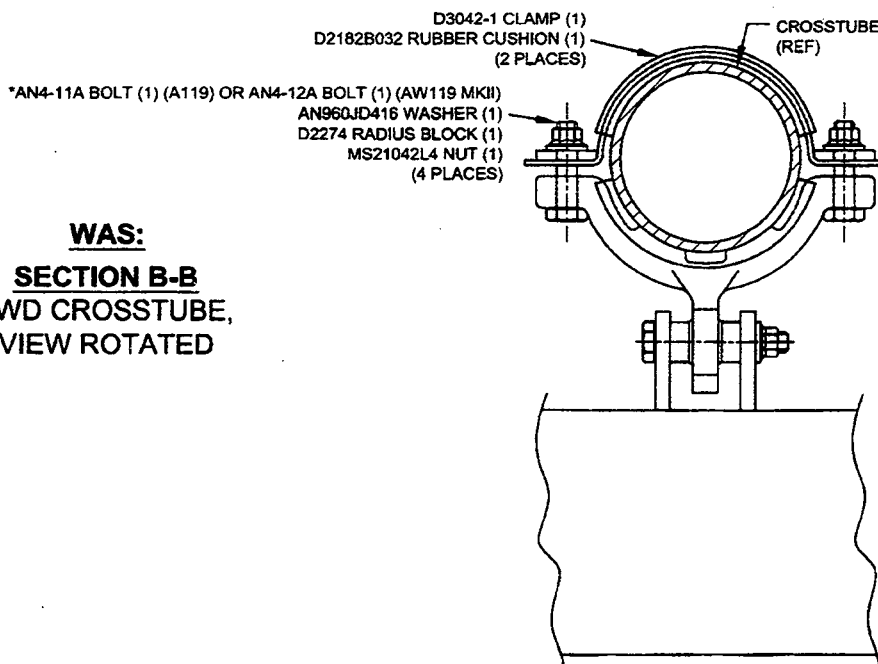
FIGURE 1 - D119-675-011/-012 HELI-ACCESS-STEP™

DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA REV. A SHEET 4 OF 6 SCALE NTS
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IS:
SECTION B-B
FWD CROSSTUBE,
VIEW ROTATED

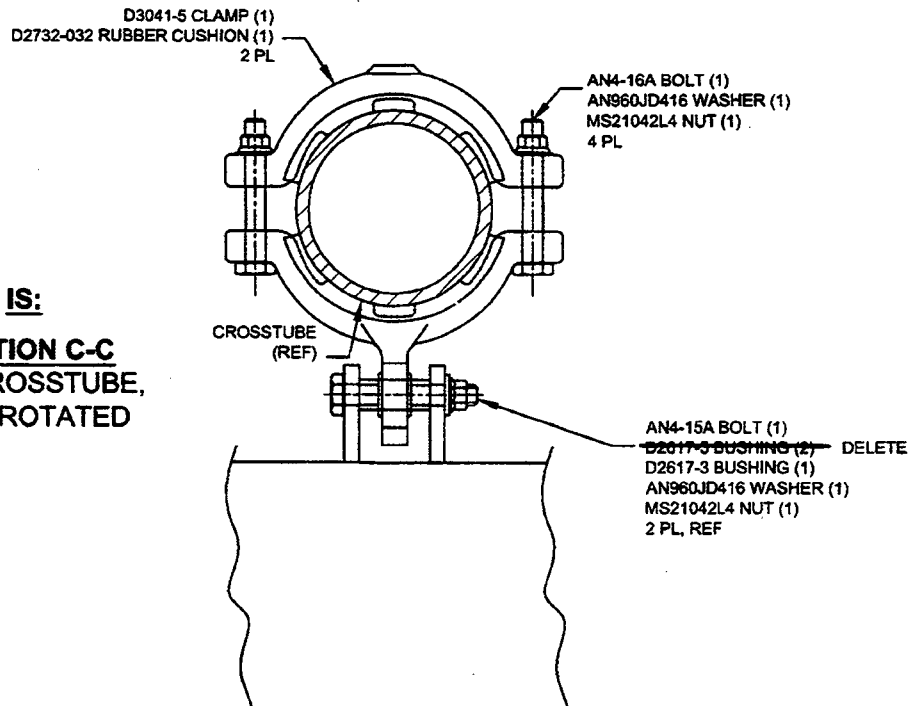


WAS:
SECTION B-B
FWD CROSSTUBE,
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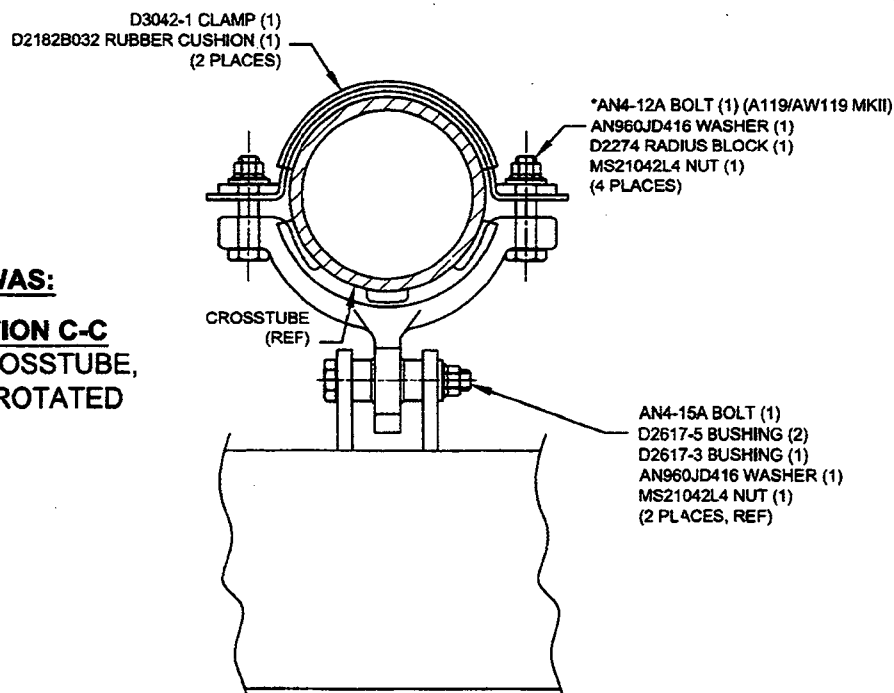





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IS:
SECTION C-C
AFT CROSSTUBE,
VIEW ROTATED



WAS:
SECTION C-C
AFT CROSSTUBE,
VIEW ROTATED



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